

Work Order ID 64335

Thursday, December 02, 2010 1:39:17 PM



Page 1

Item ID: D4106-5

Accept



Setup Start



Revision ID:

Item Name: Spacer, Sill Doubler

Stop



Start Date: 12/2/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-12-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4106	A

100

0.00



Waterjet

FLOW CNC Waterjet

Kydex

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B 10-12-20

(8)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

G 10/12/10

B 10-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Start Date: 12/2/2010 Start Qty: 8.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S012/20

78

130



Packaging

Packaging

Identify as per dwg & Stock Location: 120

0.00

Memo

0.00

10/12/20 SL \$0

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/21 JJ

MF

10-12-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, December 02, 2010 1:39:25 PM

Page 1

Work Order ID: 64335



Parent Item: D4106-5



Parent Item Name: Spacer, Sill Doulber

Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	393.5600	0.2109	1.776			

Kydex steel grey



Bp-12-20

Location	Loc Qty	Loc Code
therm	393.56	
111807	393.56	111807

8

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	64353
Description: Spacer, Sill Doubler	Part Number:	D4106-5
Inspection Dwg: D4106 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<u>J</u>	Audited by:	<u>S</u>	Preliminary Approval:	
Date:	10-12-20	Date:	10/12/20	Date:	

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	 

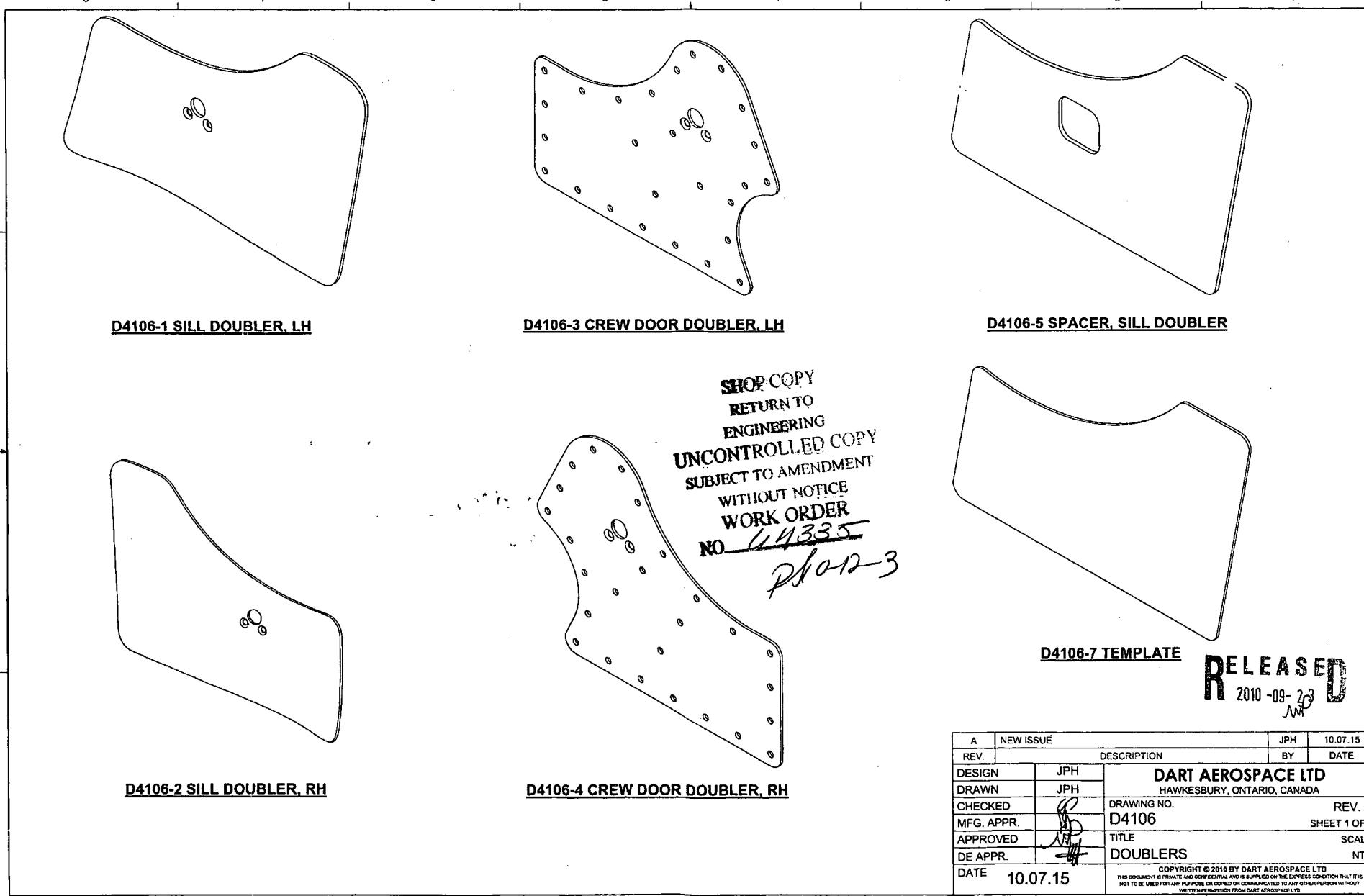
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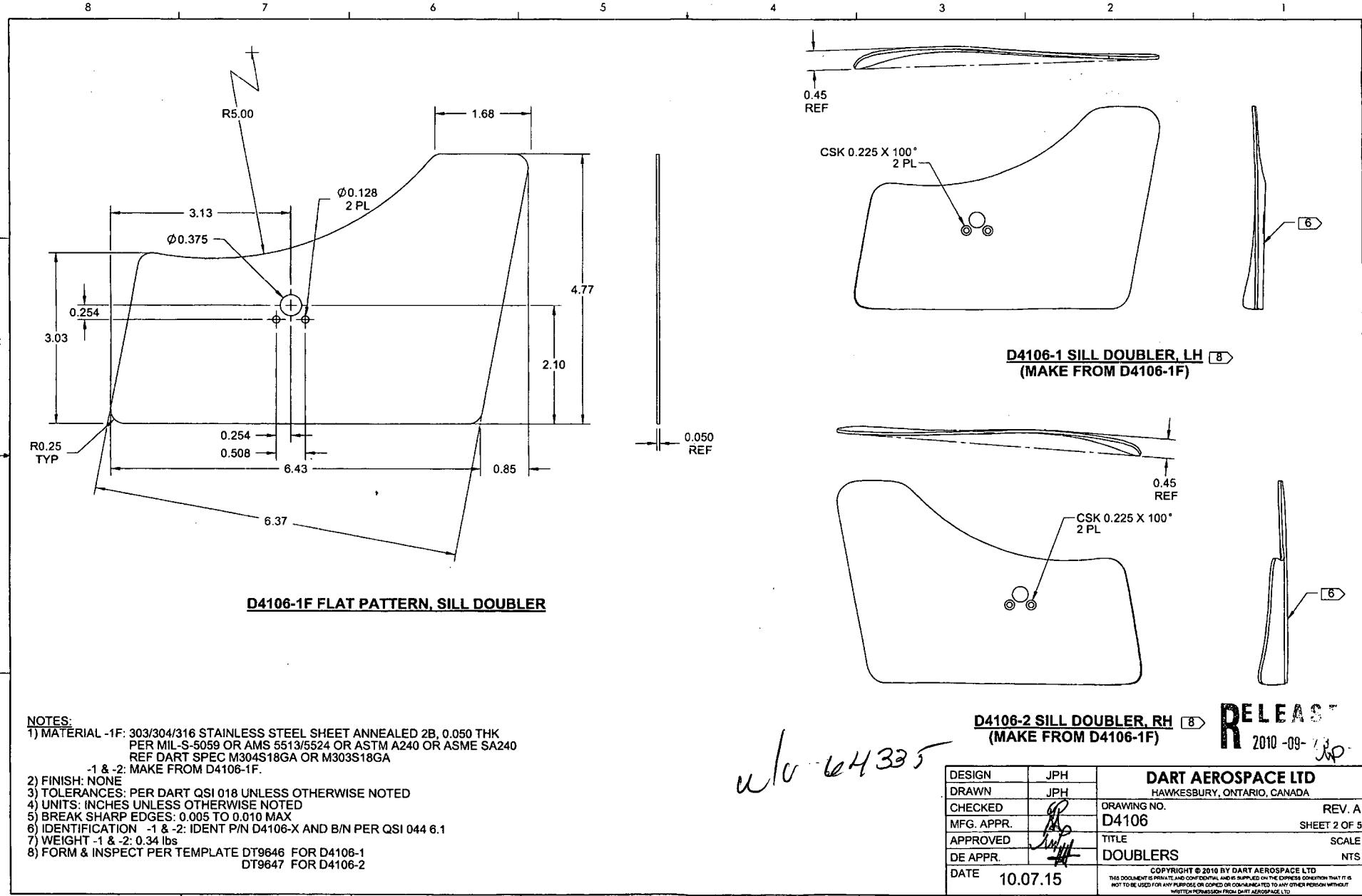
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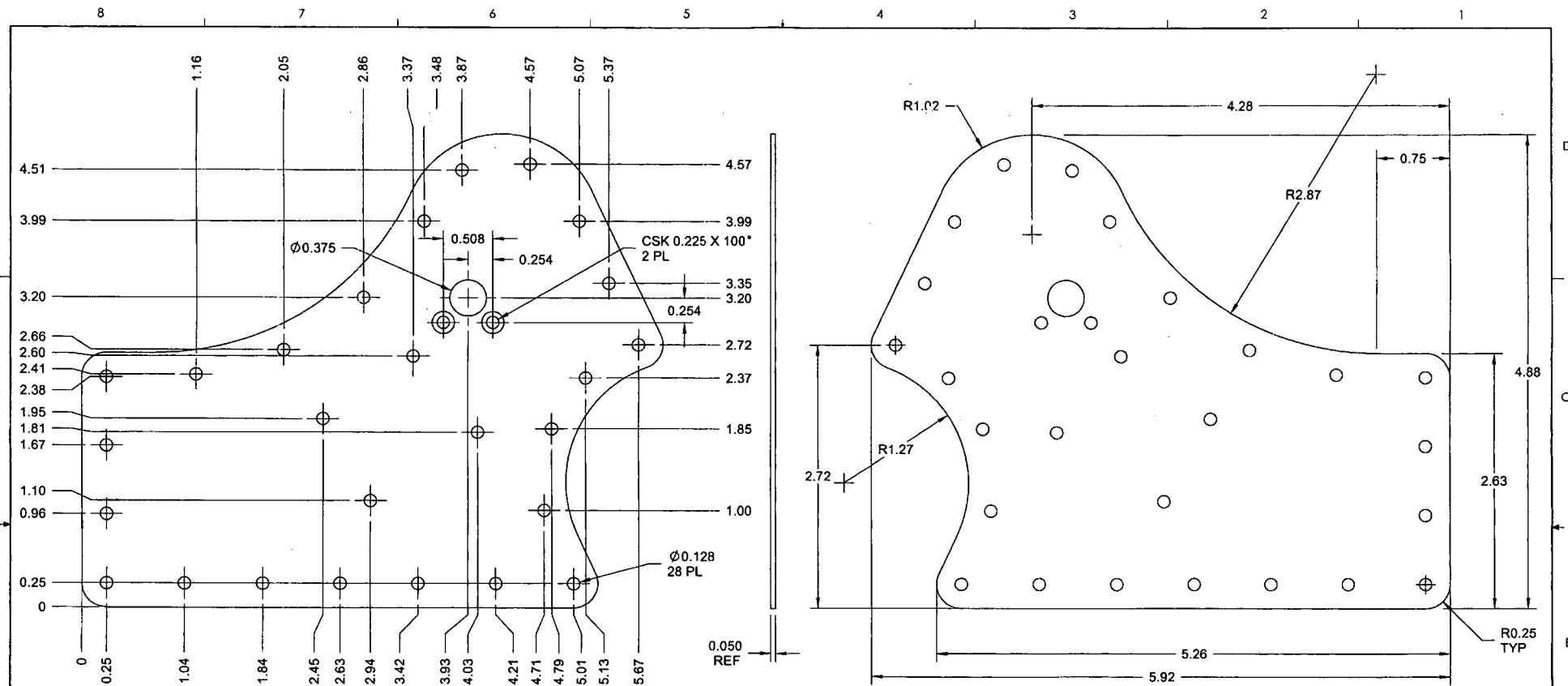
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D4106-3 CREW DOOR DOUBLER, LH

w/0 a4335

RELEASED
2010-09-23
NP

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4106	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
DATE	10.07.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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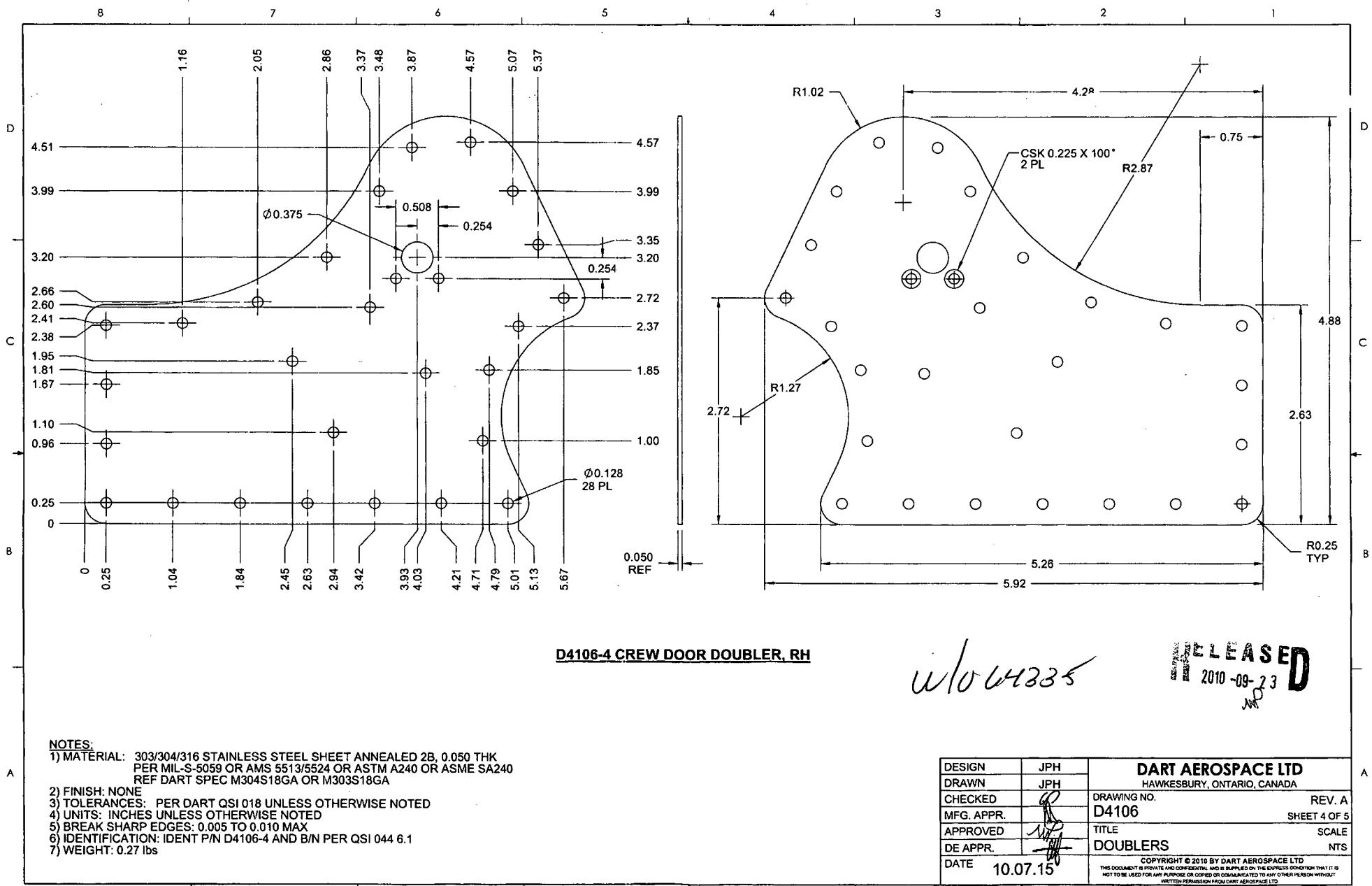
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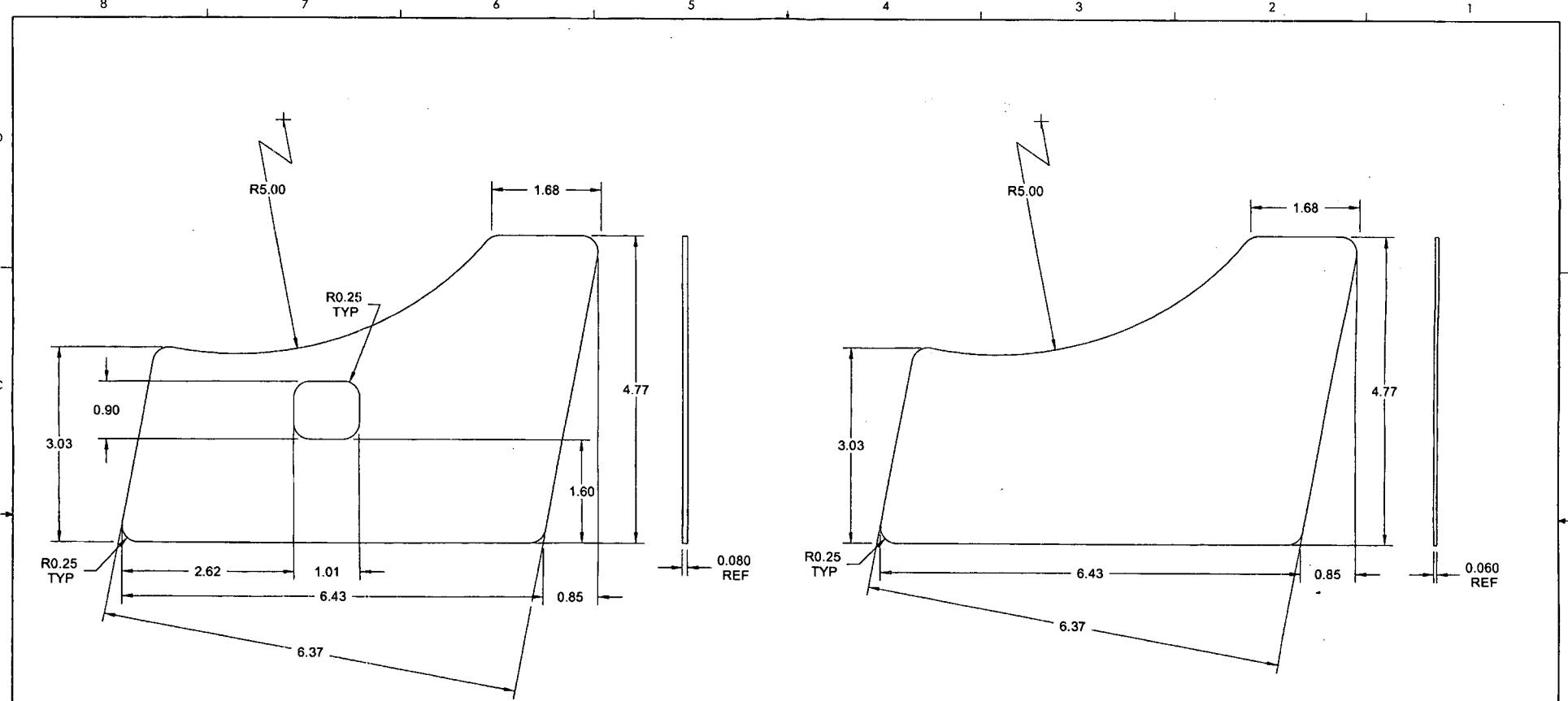
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D4106-5 SPACER, SILL DOUBLER

NOTES:

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK
REF DART MLEXS.060-9034-08
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs
-7: N/A

D4106-7 TEMPLATE

R RELEASED
2010-09-23
JW

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS	NTS
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